

Work Order ID 68970

Tuesday, April 26, 2011 2:25:17 PM



Page 1

Item ID: D3405-041

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 4/26/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: *✓*Date: *4-04-26*

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3405	Rev B

100



FLOW WATER JET

Waterjet

Memo

0.00

B11-4-27

FLOW CNC Waterjet

*304.125*1-Cut as per Dwg D3405
Dwg Rev: *B*
Prog Rev: *B*
2-Deburr if necessary*(12)*

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

B11-4-27

120



QC8- Inspect parts - second check

QC

Quality Control

Memo

0.00

0.00

*S 04/27**(a2)*

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Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Brake NC

Operation
Description

NC BRAKE

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Brake NC

Brake NC

Memo

- 1-Deburr
- 2-Form using DT8204 as per Dwg D3405
- 3- use DT9681 to check if correct forming

SB 11/04/29

(12)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5/14/29

(X/2)

150



Large Fab

Large Fab

0.00

Memo

- Weld as per Dwg D3405 use DT8484
- Identify as D3405-041

2 11/6/16

(X/2)

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC9- Inspect visual per QSI004- Fusion Welds

0.00

GL 11-06-16

QC

Quality Control

170



QC5- Inspect part completeness to step on W/O

0.00

*5/16/16 17**417*

Quality Control

180



White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

12 BL 11-6-20

Powdercoat

Powder Coating

Memo

*1:35
100°
2:05*

0.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**

Tool ID

Tool

**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Reject
Stamp**
**Insp.
Stamp**

190



QC3- Inspect Part Finish

0.00

12 6 Unalloc

QC

Memo

0.00

Quality Control

200



Identify as per dwg & Stock Location:

474

0.00

11/01/21 12

Packaging

Memo

0.00

Packaging

210



QC21- Final Inspection - Work Order Release

0.00

11/01/21 12

QC

Memo

0.00

Quality Control

MF 11-06-21

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Picklist Print

Tuesday, April 26, 2011 2:25:23 PM

Page 1

Work Order ID: 68970



Parent Item: D3405-041



Parent Item Name: Lug Assembly

Start Date: 4/26/2011

Required Date: 4/29/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A 05.09.01 New issue KJ/JLM
IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3404-1 		Manufactured	No		100		Each	30.0000	1	8			 EZ 11-676-
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GHW Lug													
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Location Loc Qty Loc Code

WA030 30

M304S11GA 		Purchased	No		150		sf	192.0000	0.154	1.296842			 2 111-4-27
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304/316 0.125 Sheet													
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Location Loc Qty Loc Code

MAT020 192

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117494													
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117494													
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(D)

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DART AEROSPACE LTD	Work Order:	68910
Description: GHW Lug	Part Number:	D3405-1
Inspection Dwg: D3405	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>BS</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	11-4-27	Date:	11/04/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue P/O D3405-041	KJ/EC	
B	09.05.04	Dimensions update per Dwg Rev. B	KJ/DD	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

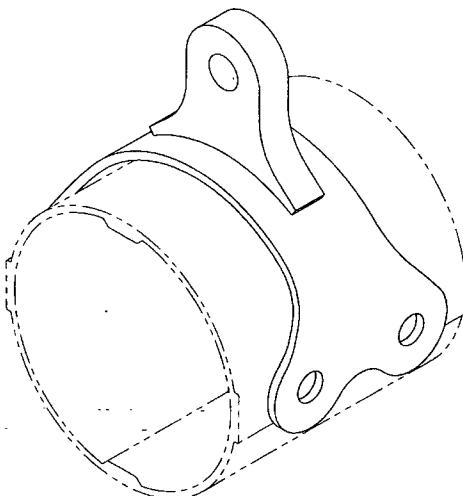
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8 7 6 5 4 3 2 1

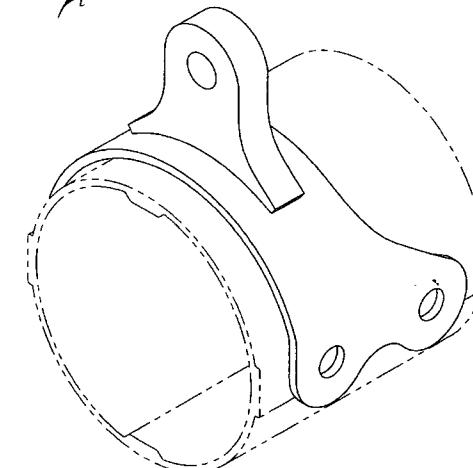
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

B



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 08970
11/04/24



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
08/21/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.			AJS	08.09.19
A	NEW ISSUE	PH	REV.	BY	DATE
DESIGN	PH	DART AEROSPACE LTD			
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV. B		
MFG. APPR.		D3405	SHEET 1 OF 4		
APPROVED		TITLE	SCALE		
DE APPR.		GHW LUG ASSEMBLY	NTS		
DATE	08.09.19				

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8 7 6 5 4 3 2 1

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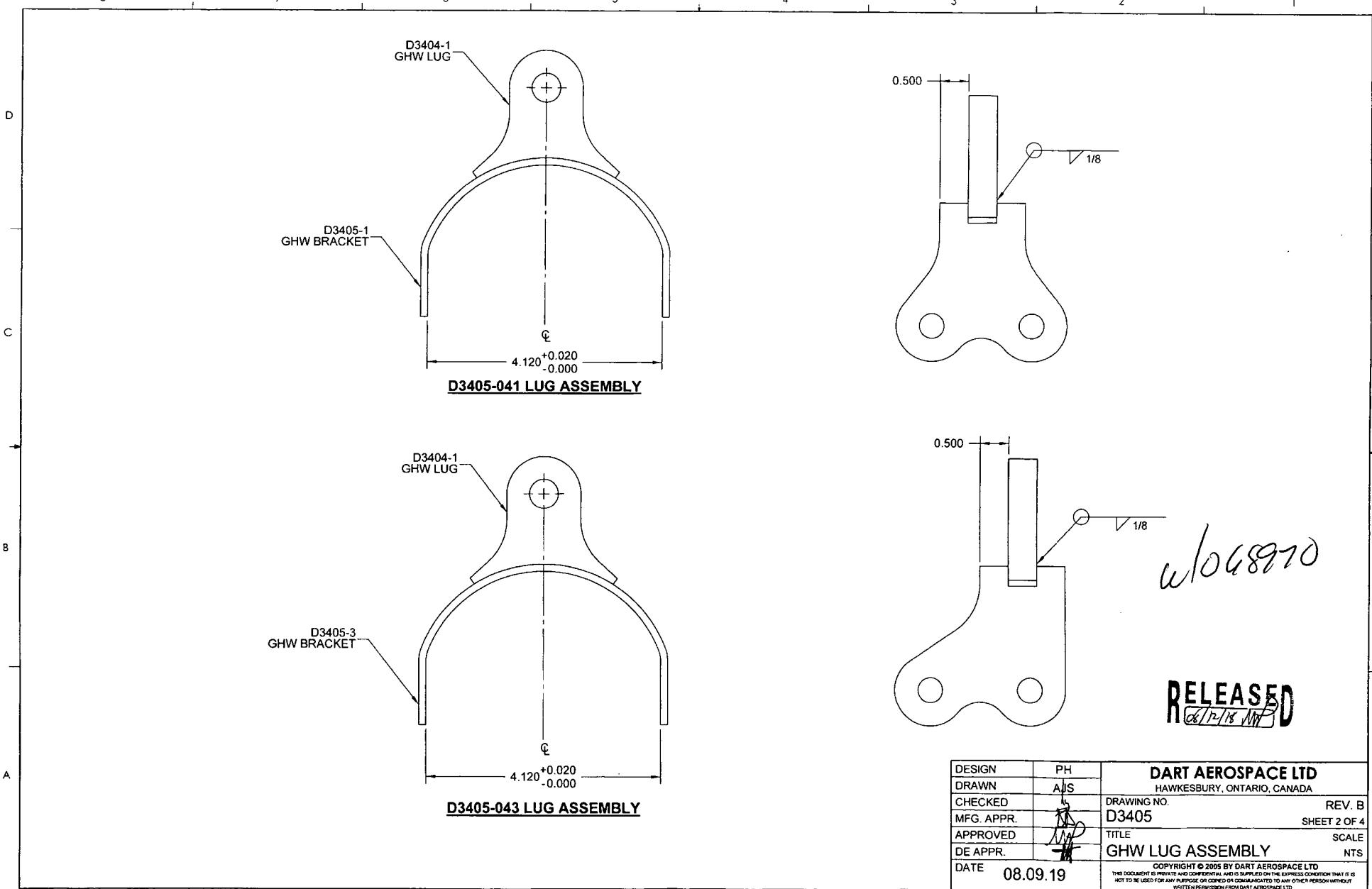
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MFG. APPR.		REV. B	
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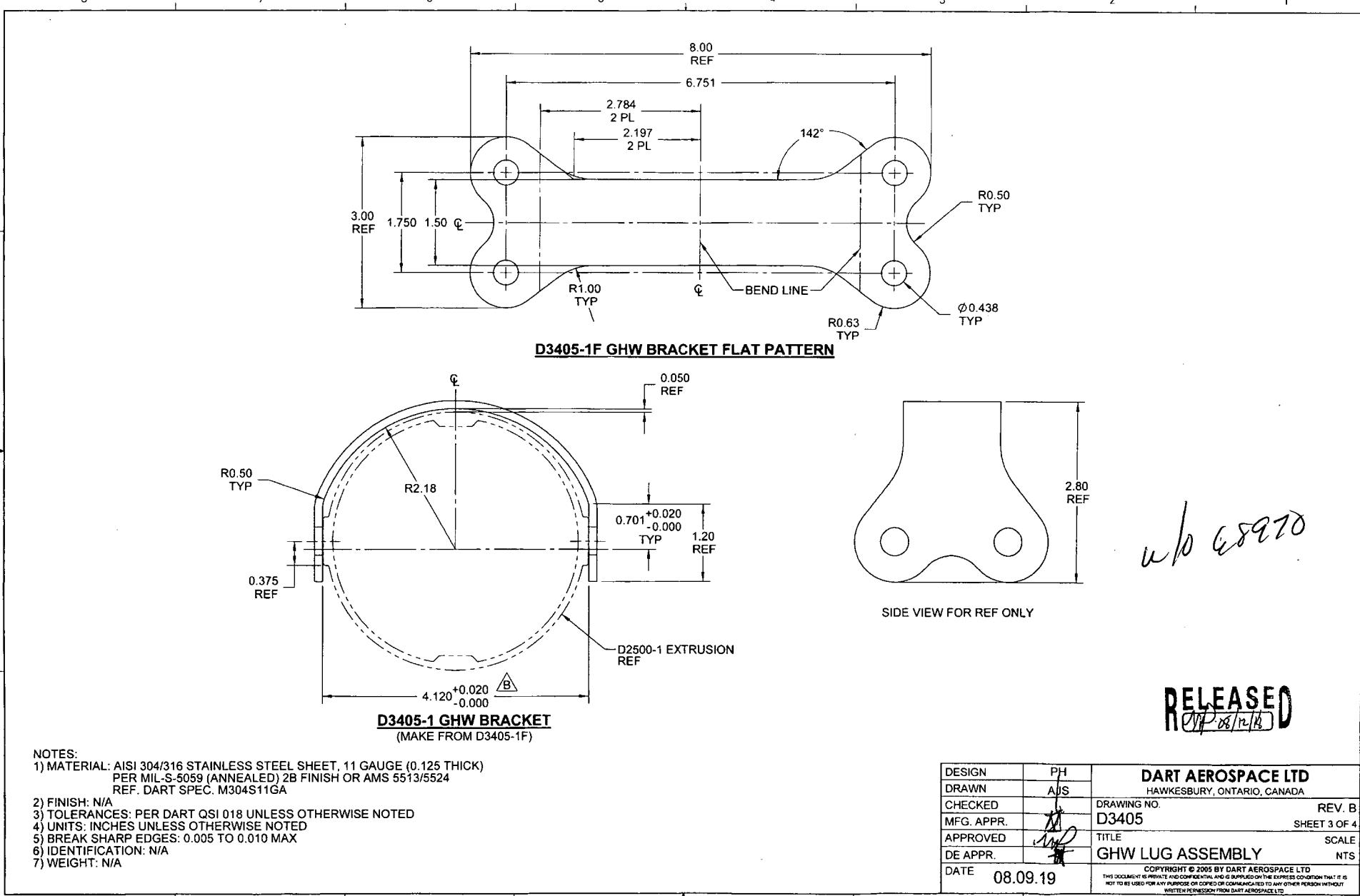
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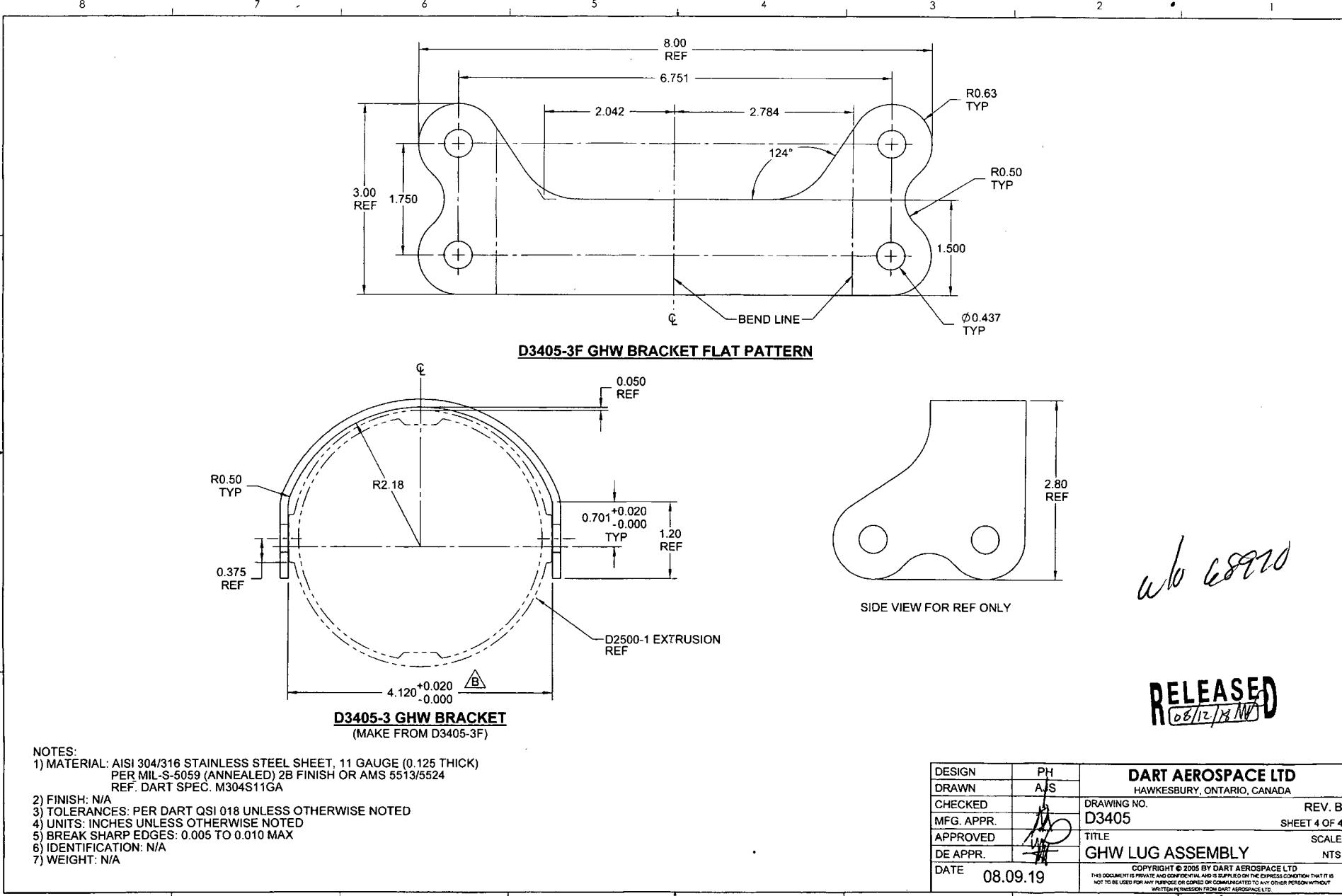
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MFG. APPR.	<i>W</i>	D3405	SHEET 4 OF 4
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